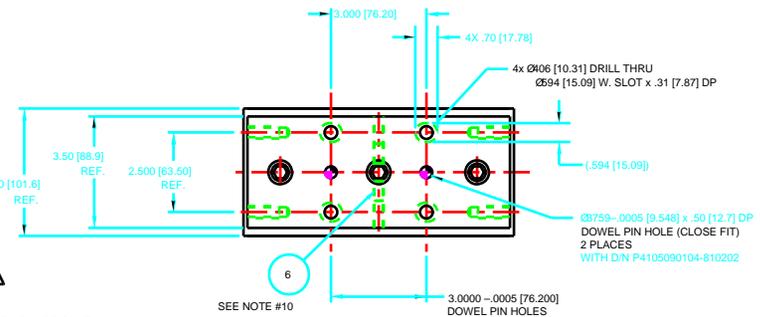
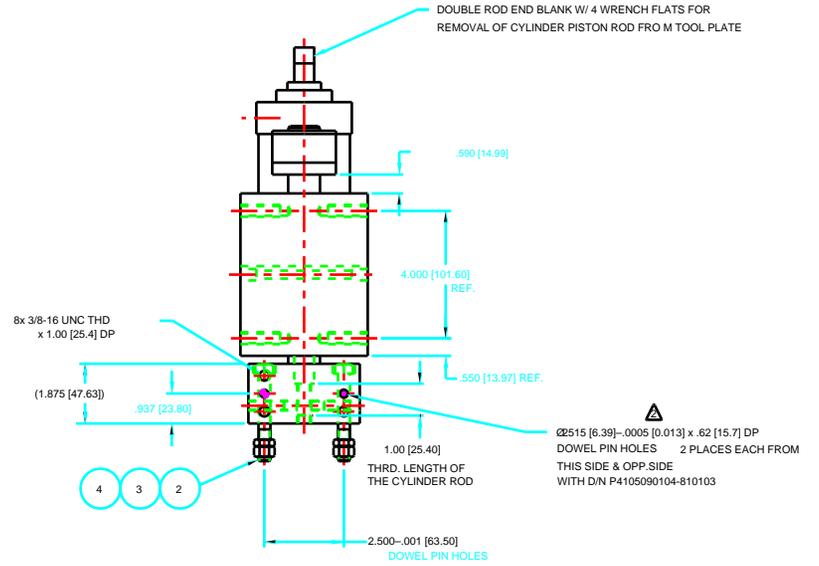
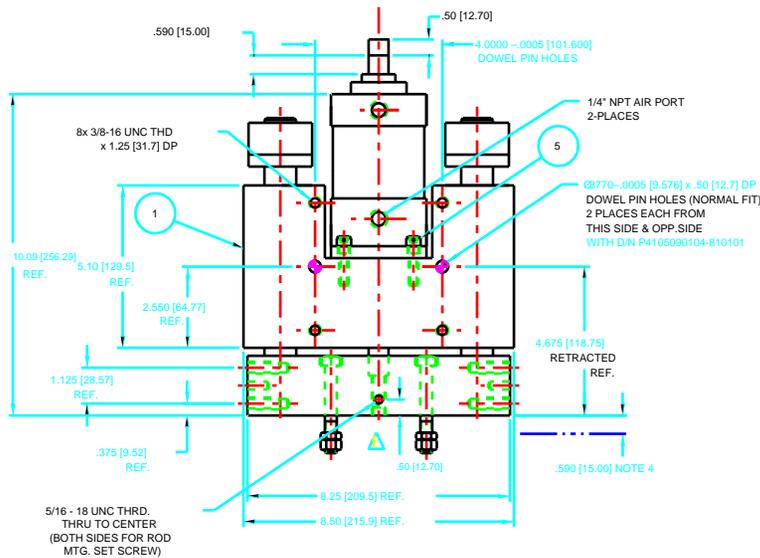


8 7 6 5 4 3 2 1



- NOTES:
- REWORK PHD POWERED SLIDE P/N TS082 x .59 X -AJ1R2-D-V
 - NO GREASE OR TEFLON COATING SHALL BE USED AS LUBRICANT.
 - NO ELASTOMER MATERIAL SHALL BE USED AS SEAL OR WIPER, EXCEPT VITON GRADED FOR 200° C.
 - ACTUATOR CYLINDER TRAVEL DISTANCE SHALL BE .590 ± .005 [15mm ± 0.12].
 - HEX HEAD SCREWS SHALL BE PLACED IN THE TOOL PLATE BEFORE ASSEMBLY.
 - ALL DIMENSIONS WITH [] ARE MILLIMETERS.
 - LUBRICATE ALL THE VITON SEALS WITH DOW CORNING 710 FLUID LUBRICANT. THEN TEST THE CYLINDER FOR PROPER ACTUATION. FLANGE SIDE COMPRESSION SEAL ON PISTON BE POLY PAC. DOW CORNING 710 IS NOT DESIRABLE IN VACUUM. CARE MUST BE EXERCISED TO AVOID CONTAMINATION OF THE VACUUM CHAMBER DURING ASSEMBLY, TEST AND SHIPMENT.
 - REPLACE CAST IRON GRAPHITE FILLED BUSHING WITH BRONZE 660 BUSHING.
 - SET SCREW TO BE LOOSEN FOR REMOVAL OF CYLINDER ROD. FROM TOOL PLATE

SOURCE

PHD, INC.
AIRPORT AND PIPER DR.
FORT WAYNE, IN 46899
PHONE: (219) 747-6151

| | | | |
|---|-------------------------------------|-----|---|
| 6 | 5/16 - 18 X 3/8" LG. SET SCREW | SST | 2 |
| 5 | 5/16 - 18 X 1 1/4" LG. DR. HD. SHCS | SST | 4 |
| 4 | 3/8-16 UNC-2B HEX NUT | SST | 4 |
| 3 | 3/8-16 UNC-2B HEX NUT | SST | 4 |
| 2 | 3/8-16 UNC-3A X 2-3/4 LG. HHCS | SST | 4 |
| 1 | TS08 PHD SLIDE | | 1 |

| | | | | | |
|-----------------------------------------------------------------|-----------------|------------------------------------------------|---------|-----------------------------------------------------------------------------------------------|----------|
| UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES | | LOG NUMBER A4710001-03 | | THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY | |
| TOLERANCES | | ANGULAR | | PROJECT NUMBER A4-71 15mm HEAVY LOAD PNEUMATIC ACTUATOR GUIDED CYLINDER SLIDE MODIFICATION | |
| DECIMAL | FRACTIONAL | ANGLE | DATE | DATE | DATE |
| X | XXX - | XXX - | 10/5/98 | 10/19/98 | 10/20/98 |
| SURFACE ROUGHNESS | | REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. | | PROJECT LEADER M. KUZAY | |
| SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 | | RESPONSIBLE ENGINEER J. CHANG | | DATE 10/19/98 | |
| DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5 | | MATERIAL SEE PARTS LIST | | SCALE 1=2 | |
| BY M.J.M. J.C. | | DATE 3/8/99 | | SHEET 1 of 1 | |
| DATE 4/12/00 | | DATE 1/18/99 | | DRAWING NUMBER A4-710001-03 | |

8 7 6 5 4 3 2 1